

Work Order ID 73940

Tuesday, September 20, 2011 9:09:35 AM



Page 1

Item ID: D3821-1KGY

Accept



Setup Start



Revision ID:

Item Name: Panel w/o Rotor Brake-Grey

Stop



Start Date: 9/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-09-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3821-1

Rev. B

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

[Signature]
11/12/21

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: *150°F*

Time IN: *4:00 AM*

Time OUT: *7:00 AM*

11/12/20
11/12/21

[Signature]
11/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA023 using tool DT9053 Dwg Rev: <u>B</u> Folio Rev: <u>B</u>	0.00 0.00				<u>x2</u>			<u>Dh</u> <u>11/22/11</u>
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture	0.00 0.00				<u>x2</u>			<u>Dh</u> <u>11/22/11</u>
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>x2</u>			<u>Suliz/zz</u>

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Page 3

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Required Date: 9/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandThermo	Memo	0.00				x2			DL 11/12/12
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150 QC	QC2- Inspect parts off machine FAI/FAIB	0.00				x2			DL 11/12/12
Quality Control	Memo Complete FAI document	0.00							
160 QC	QC5- Inspect part completeness to step on W/O	0.00				(x2)			DL 11/12/12
Quality Control	Memo	0.00							

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Page 4

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Start Date: 9/20/2011 Start Qty: 2.00



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Required Date: 9/27/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/12/2011

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/2011

mf

11-12-20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 9:09:41 AM

Page 1

Work Order ID: 73940

Parent Item: D3821-1KGY

Parent Item Name: Panel w/o Rotor Brake-Grey

Start Date: 9/20/2011

Required Date: 9/27/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev. A New Issue DL
Ipp Rev. B Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	436.3796	12.79	25.5928			



Kydex steel grey



Location

therm

Loc Qty

436.3796282

436.379628

Loc Code

114807
119476

25.5928 sq ft

DL
11/17/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73940
Description: Panel, without Rotor Brake		Part Number:	D3821-1KIV/KGY
Inspection Dwg: D3821	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	<input checked="" type="checkbox"/>			
Shape Definition	<input checked="" type="checkbox"/>			
Texture Retention	<input checked="" type="checkbox"/>			
Material imperfections such as bumps, cracks, voids, scratching	<input checked="" type="checkbox"/>			

Measured by: DF Date: 11/12/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	Min	1.10"	<input checked="" type="checkbox"/>		Visual	
0.75	Min	0.8"	<input checked="" type="checkbox"/>		Visual	
0.63	Min	0.67"	<input checked="" type="checkbox"/>		Visual	
0.25	Min	0.27"	<input checked="" type="checkbox"/>		Visual	
0.375	Min	0.50"	<input checked="" type="checkbox"/>		Visual	

Measured by: DF Date: 11/12/22
Audited by: J Date: 11/12/22
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	<u>[Signature]</u>

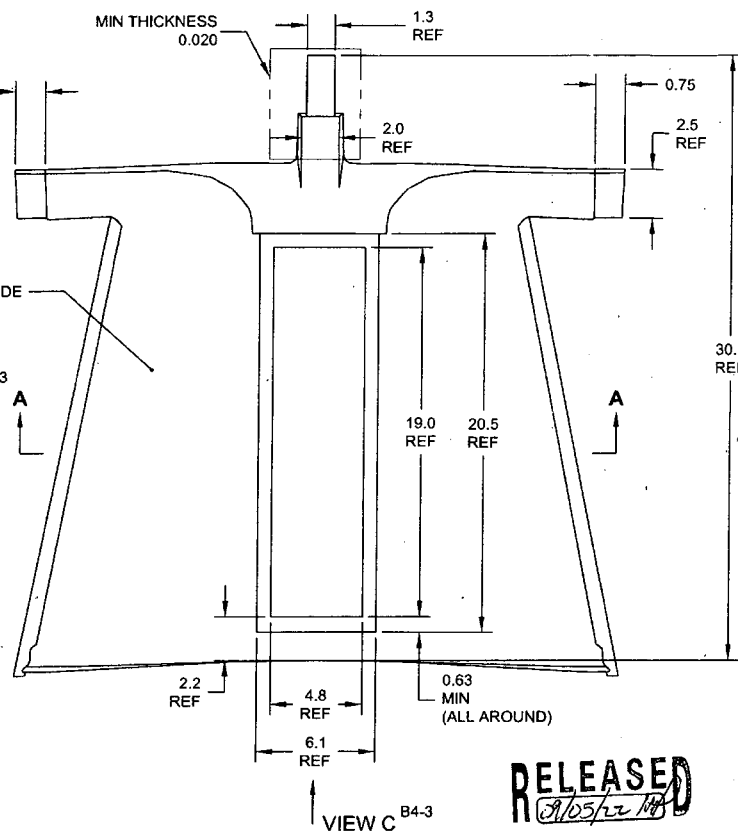
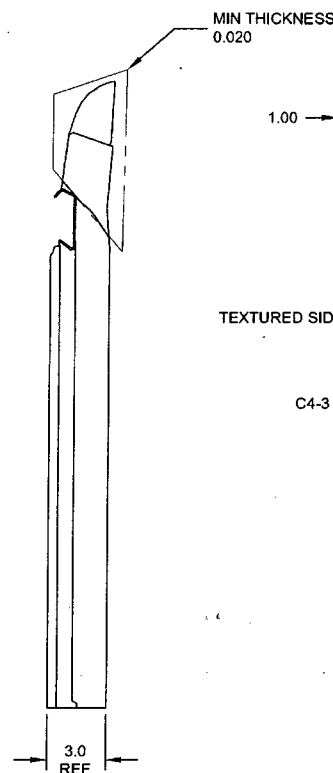
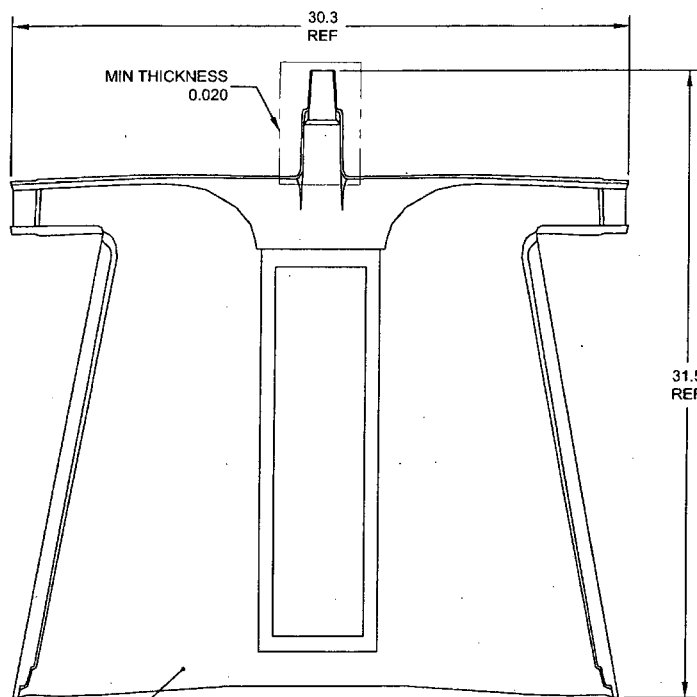
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 139416

D3821-1 PANEL, WITHOUT ROTOR BRAKE
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9053 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3821-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3821-1KGy	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

REV. B	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3821-1KIV, D3821-3KIV AND ADD STEEL GRAY P/N'S D3821-1KGy, D3821-3KGy (ZN A5-1, A5-2)	PH	09.05.05
REV. A	NEW ISSUE	PH	08.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3821 TITLE PANEL (BELL 206 A/B) REV. B SHEET 1 OF 4 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
3/10/12 MB

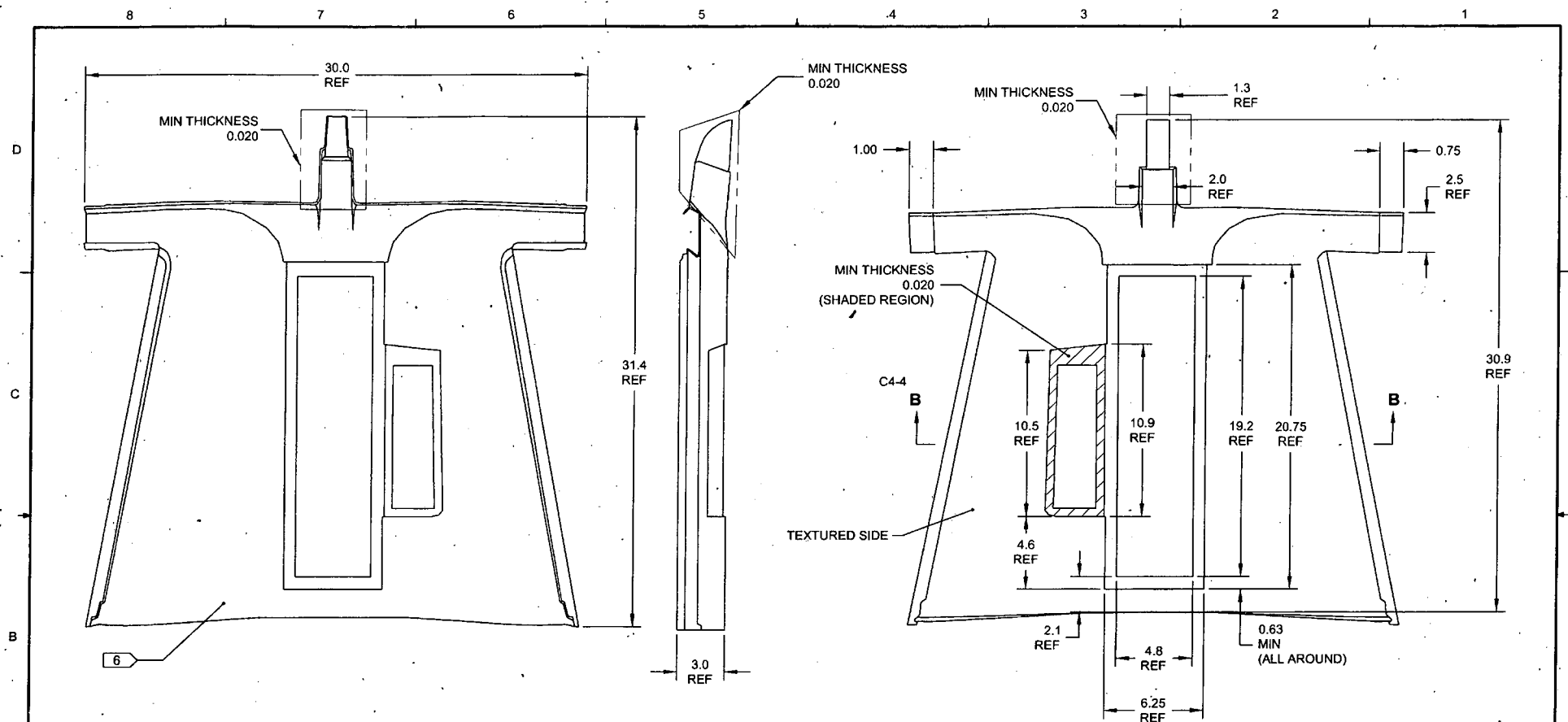
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3821-3 PANEL, WITH ROTOR BRAKE
(BELL 206 A/B)

VIEW D B4-4

RELEASED
09/05/05

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9054 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3821-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3821-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3821 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		PANEL (BELL 206 A/B) NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD
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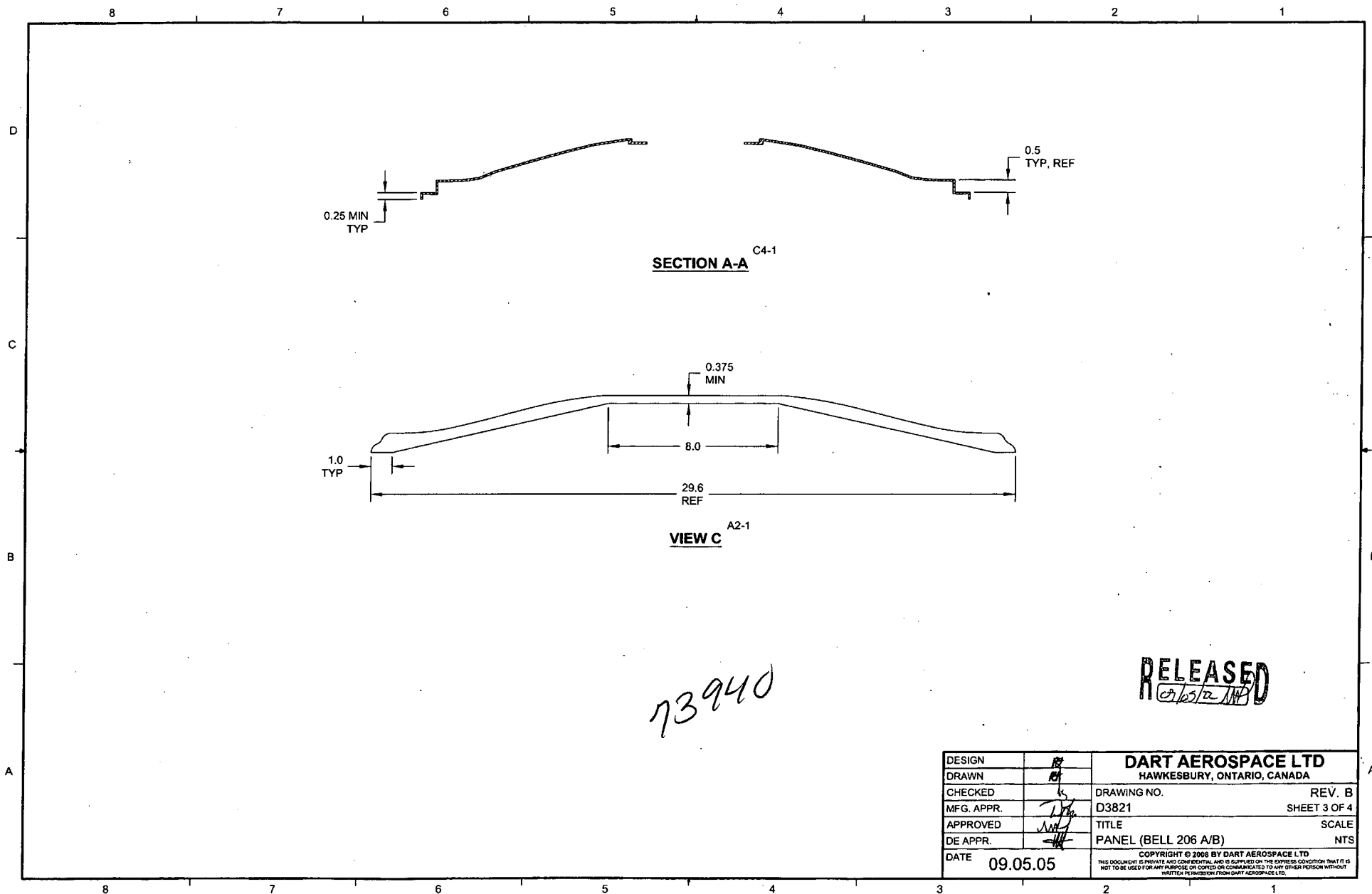
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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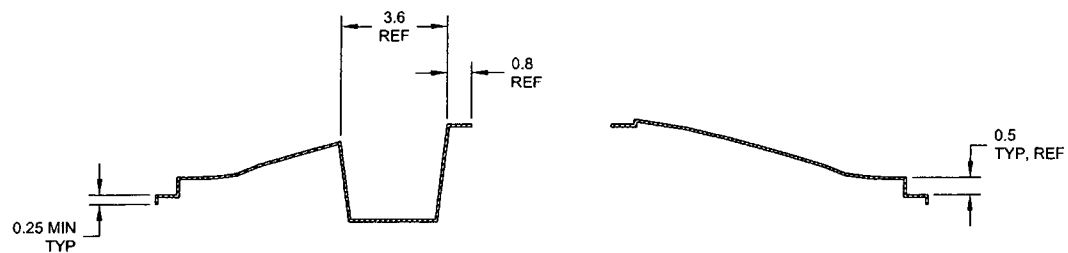
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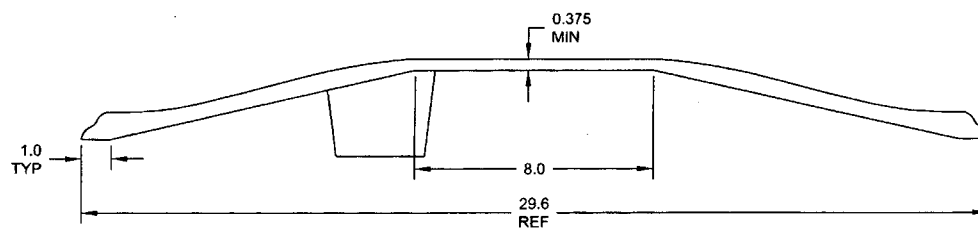
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION B-B C4-2



VIEW D C4-2

13940

RELEASED
09/25/22 JH

DESIGN	RE	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RE	DRAWING NO.	REV. B
MFG. APPR.	RE	D3821	SHEET 4 OF 4
APPROVED	RE	TITLE	SCALE
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